

Date: Thursday, 2/23/2006 10:21:14 AM
 User: Kim Johnston

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|-------------------------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B |
| Job Number : | 25902A | | |
| Estimate Number : | 10163 | | |
| P.O. Number : | N/A | Part Number : | D206642241 |
| This Issue : | 2/23/2006 | S.O. No. : | N/A |
| Prsht Rev. : | NC | Drawing Number : | D2650 REV D1 |
| First Issue : | N/A | Project Number : | N/A |
| Previous Run : | 25901A | Drawing Revision : | D1 |
| | Type : | Material : | N/A |
| | LANDING GEAR | Due Date : | 3/30/2006 |
| Written By : | See Comment Below | Qty: | 1 |
| Checked & Approved By : | KJ 06-02-23 | Um: | Each |
| Comment : | Est Rev:M 04.12.02 Revised procedural steps KJ/JLM | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-------|-------------------|
| 1.0 | D2620 | Bent 206 Skidtube |
|-----|-------|-------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
|-----|-------------|-------------|-------|

| | | | |
|---|-------|-----------------|-----------------|
| 1 | D2620 | Bent Tube 3" OD | BE 06-02-27 (1) |
|---|-------|-----------------|-----------------|

| | | |
|-----|--------|---------|
| 2.0 | D32861 | Doubler |
|-----|--------|---------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
|-----|-------------|-------------|-------|

| | | | |
|---|---------|---------|-----------------|
| 2 | D3286-1 | Doubler | BE 06-03-02 (1) |
|---|---------|---------|-----------------|

| | | |
|-----|-------|-----|
| 3.0 | D2647 | Cap |
|-----|-------|-----|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
|-----|-------------|-------------|-------|

| | | | |
|---|-------|---------|-----------------|
| 1 | D2647 | Fwd Cap | BE 06-02-27 (1) |
|---|-------|---------|-----------------|

| | | |
|-----|----------------|-------------------------|
| 4.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

BE 06-02-27 (1)

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

BE 06-02-27 (1)

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
|-----|-------------|-------------|-------|

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Job Number: 25902A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

- A/R Aluminum Rod m 18839 / m 19100 BE 06-02-27 ①
- 4-Grind weld flush to cap on top surface only. BE 06-02-27 ①
- 5-Cut Aft end as per dwg 2650 from front of tube and Deburr BE 06-03-01 ①
- 6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650 BE 06-03-02 ①
- 7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025. BE 06-03-02 ①
- 8-Drill pilot holes using Dt 8167. BE 06-03-02 ①
- 9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support. BE 06-03-03 ①
- 10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time. BE 06-03-03 ①
- 11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads. BE 06-03-03 ①
- 12-Remove and Deburr D3286-1 doubler BE 06-03-03 ①
- 13-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650 BE 06-03-03 ①
- 14-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder BE 06-03-03 ①
- 15-Remove indexing edge using DT8741 as per Dwg D2650 BE 06-03-15 ①
- 16-C'sink GHW rivet holes as per Dwg D2650 BE 06-03-15 ①

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1




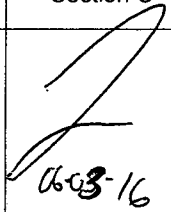
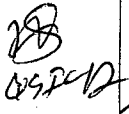
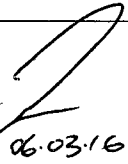
Comment: LANDING GEAR RESOURCE 1

- 1-Open crossbolt holes to Ø0.3125" as per Dwg D2650 BE 06-03-16 ①
- 2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6. BE 06-03-16 ①

Dart Aerospace Ltd

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| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/25
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|----------------------------------|--|--|----------------|--|---|--|
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| 06-03-16 | 4.11 | 1 # 30 hole drilled crooked. |  | Fill hole with weld as per QSI with copper plug inside. re-drill and sink as per dwg. grind flush. Inspect 5/9 | BE 06-03-16 |  06-03-16 |  06-03-16 |  06-03-16 |
| | | | | | | | | |
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Job Number: 25902A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Deburr tube and blow out chips from inside the tube

BE 06-03-16 (1)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MM 06-03-17 (1)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 06-3-17 (1)

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)

BE 06-3-17 (1)

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

BE 06-3-17 (1)

3-Deburr and blow out all chips from inside the tube

BE 06-03-17 (1)

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

m-3.20

11.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number

Description Batch

52 CR3212-4-04 Rivet

MI9185

BE 06-03-20 (1)

12.0

D26543

206 I-Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2654-3

Web

B-25979 BE 06-03-20 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number: 25902A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 06-03-20 Time: 2:00

Finish Date: 06-03-22 Time: 10:30

BE 06-03-22 (1)

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 m19597

Sikaflex expire date: 06-06-18

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 06-3-22

(1)

15.0

D2649

Crossbolt Spacer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2649 Crossbolt spacer

B24200 BE 06-03-22 (1)

16.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3 Spacer

B24711 BE 06-03-27 (1)

17.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

m18839 BE 06-03-22 (1)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number: 25902A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Grind welds flush as per Dwg D2650.

BE 06-03-27 (1)

3-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R SS Rod N/USED

BE 06-03-27 (1)

4-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

BE 06-03-27 (1)

18.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets

m18548

BE 06-03-27 (1)

19.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 M7885/3-4-3 Rivets

m7808

BE 06-03-27 (1)

20.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041 Nut Plate

B21103

BE 06-03-27 (1)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

BE 06-03-27 (1)

22.0

QC5/9

WELD INSPECTION



PD 06-03-23

06-03-28

Comment: Inspect weld and Counterbore work to Current Step. Inspect for foreign objects as per QSI 024

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 25902A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

a.m. 06/05/10

(1)

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PL 06/05/10

(1)

25.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 D2648-3

Wearpad *B24843-2*

26.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-13

Wearshoe *WASHOE B 25914*

27.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-21

Wearshoe *B20532*

28.0

D265633

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-33

Wearshoe *B20213*

a.m. 06-05-10

(1)

| W/O: | | WORK ORDER CHANGES | | | | | |
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Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3429-1

Wearpad

B24417

30.0

ALS41032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

✓ 44 ALS4-1032-130 Inserts

M18293

or (see QSI 017)

31.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 AN960JD10L

Washer

M18235

32.0

MS27039108

Screw



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 MS27039-1-08

Screw

M1836

33.0

D26511

Plug



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

18 D2651-1

Plugs

B25265

a.m 06-05-10

①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

D26513

O-Ring



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2651-3 O-Rings 1323491 /

35.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-4-06 Screw 116874 /

36.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD416 Washer 111151 /

A.M. 06-05-10

37.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before install wearpad/wearplate.

A/R Sikaflex-291 1100901

Sikaflex expire date: 06-11-06

A.M. 06-05-10

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Drawing D206642241. Excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

A.M. 06-05-10

38.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect for foreign objects as per QSI 024

FC

Dart Aerospace Ltd

W/O:

DATE

STEP

WORK ORDER C...

| WORK ORDER CHANGES | | | | | | | |
|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
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Seq. #:

Machine Or Operation:

Description :

39.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646

Aft Cap

023370B ✓

40.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw

M18836 ✓

41.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer

M18235

a.m 06-05-10 ①

42.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

M100901

Sikaflex expire date:

06-11-06

a.m 06-05-10 ①

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch:

M100652

a.m 06-05-23 ①

43.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

Ref 24 ①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LP Date: 06/15/25
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:21:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 25902A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

44.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

PP 06/05/25 (1)

Job Completion



u dec 5.28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2650 | REV. D SHEET 1 OF 5 |
| DATE 04.05.17 | | TITLE 206/407 SKIDTUBE ASSEMBLIES | SCALE NTS |
| A | 97.03.25 | NEW ISSUE | |
| B | 97.06.26 | AS MANUFACTURED CHANGES | |
| C | 97.10.29 | CHANGE HOLE PATTERN AND FRONT END | |
| D | 04.05.17 | REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3 | |

RELEASED
04.06.22 *[Signature]*

| Qty -1 | Qty -3 | Qty -5 | Qty -7 | Part Number | Description |
|-----------|-----------|-----------|-----------|---------------|---|
| X | | | | D2650-1 | SKIDTUBE ASSEMBLY |
| | X | | | D2650-3 | SKIDTUBE ASSEMBLY |
| | | X | | D2650-5 | SKIDTUBE ASSEMBLY |
| | | | X | D2650-7 | SKIDTUBE ASSEMBLY |
| 1 | 1 | 1 | 1 | D2600-1-160 | EXTRUSION |
| 1 | | | | D2654-1 | WEB |
| | 1 | | | D2654-3 | WEB |
| | | 1 | | D2654-5 | WEB |
| | | | 1 | D2654-7 | WEB |
| 1 | 1 | 1 | 1 | D2646 | AFT CAP |
| 1 | 1 | 1 | 1 | D2647 | CAP |
| 16 | 17 | 19 | 23 | D2649 | CROSS BOLT SPACER |
| 16 | 18 | 14 | 22 | D2651-1 | PLUG |
| 16 | 18 | 14 | 22 | D2651-3 | O-RING |
| 1 | 1 | 1 | 1 | D2680-041 | NUT PLATE |
| 2 | 2 | | | D3286-1 | DOUBLER |
| 2 | 2 | | | D3286-3 | STUD |
| 42 | 44 | 54 | 60 | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130) |
| 2 | 2 | 2 | 2 | AN960JD10L | WASHER |
| 2 | 2 | 2 | 2 | CCR264SS3-3 | RIVET |
| 2 | 2 | 2 | 2 | CR3212-4-03 | RIVET |
| 2 | 2 | 2 | 2 | MS27039-1-08 | SCREW |
| 1 | 1 | 1 | 1 | MS27039-4-06 | SCREW |
| 1 | 1 | 1 | 1 | AN960JD416 | WASHER |
| 52 | 52 | | | CR3212-4-04 | RIVET |

NOTES

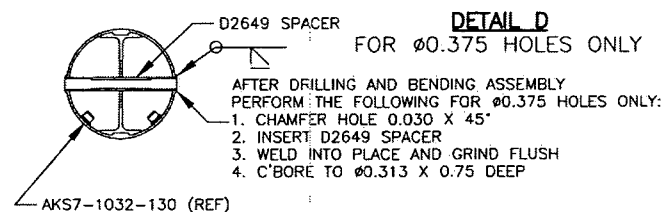
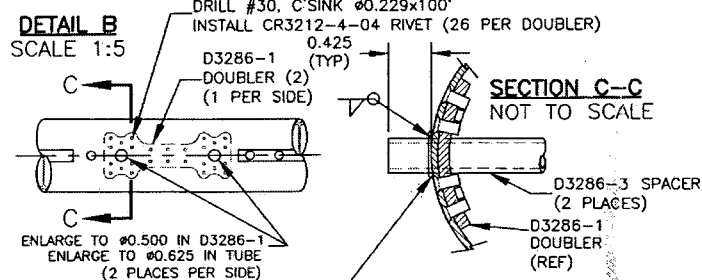
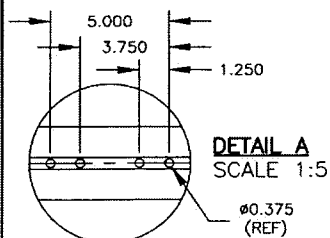
- 1) WELD PER DART QSI 004
- 2) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 3) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 4) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 5) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 6) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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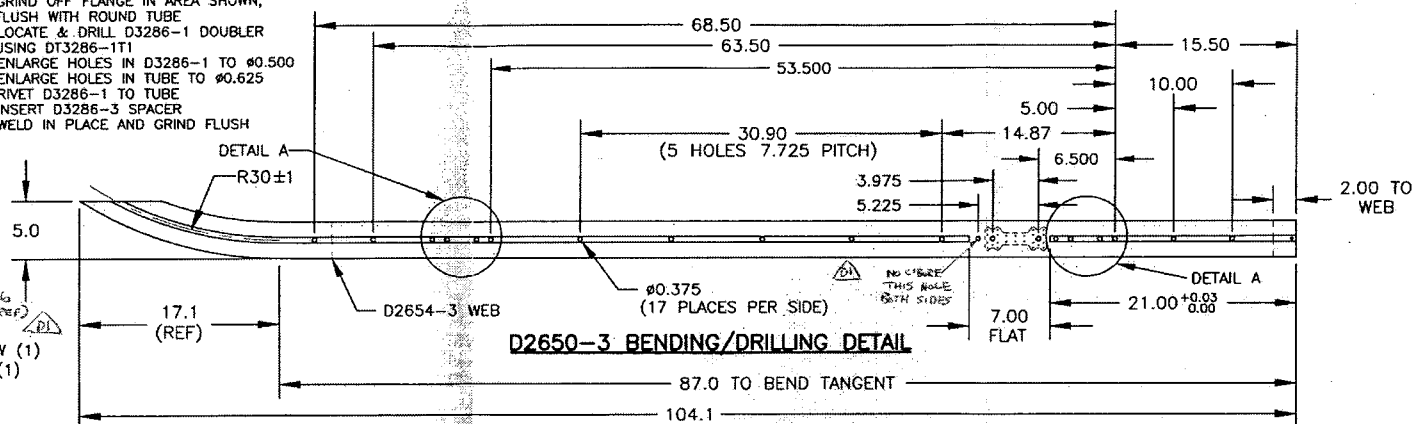
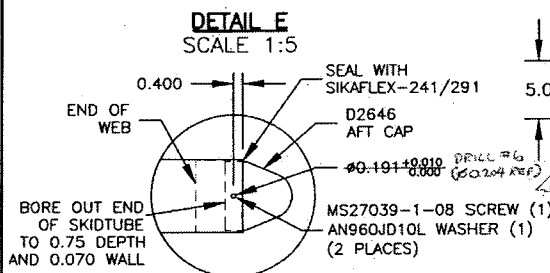
AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:

1. CHAMFER HOLE 0.030 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313 X 0.75 DEEP

TO INSTALL D3286-1/-3:

1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
3. ENLARGE HOLES IN D3286-1 TO Ø0.500
4. ENLARGE HOLES IN TUBE TO Ø0.625
5. RIVET D3286-1 TO TUBE
6. INSERT D3286-3 SPACER
7. WELD IN PLACE AND GRIND FLUSH

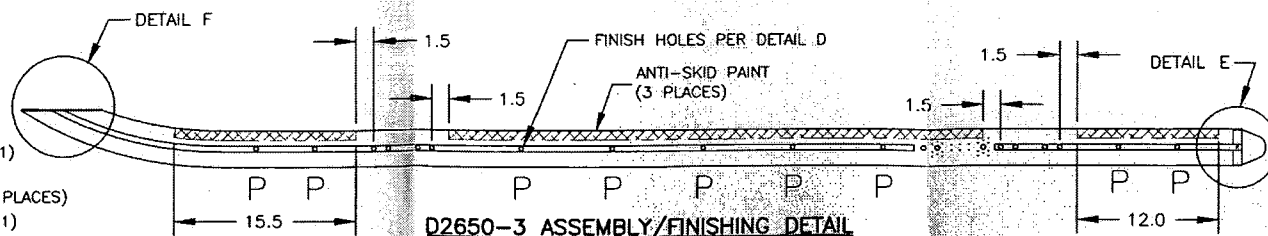
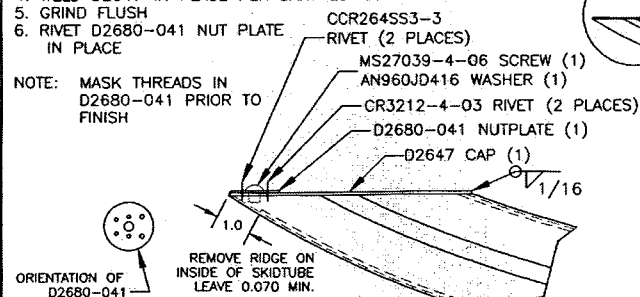
RELEASED
01-06-22



DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART OSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



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| CHECKED | APPROVED | DRAWING NO. | D2650 | | REV. D | | SHEET 3 OF 5 |
| DATE | 04.05.17 | TITLE | SKIDTUBE | | SCALE | | 1:10 |

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| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D2966 | REV. A SHEET 1 OF 2 |
| DATE 00.03.08 | | TITLE BO 105 SKIDTUBE ASSEMBLY | SCALE NTS |
| A | 00.03.08 | NEW ISSUE | |

RELEASED
00.05.11 #

REFERENCE ONLY

| Qty | Part Number | Description |
|-----|---|-------------------|
| X | D2966-041 | SKIDTUBE ASSEMBLY |
| 1 | D2962-125 | EXTRUSION |
| 1 | D2964 | CAP |
| 1 | D2965 | CAP |
| 1 | D2970-1 | WEARPLATE |
| 1 | D2970-3 | WEARPLATE |
| 1 | D2971 | CROSS BOLT SPACER |
| 7 | D2973 | CROSS BOLT SPACER |
| 1 | D2976 | WEB |
| 36 | ALS7-1032-130 or ALS4-1032-130 or AKS7-1032-130 or AKS4-1032-130 | INSERT |
| 28 | AN960JD10L | WASHER |
| 26 | MS27039-1-08 | SCREW |
| 2 | MS27039-1-09 | SCREW |
| 1 | D3176-1 | BUSHING |
| 1 | D3176-3 | NUT |

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELDING TO BE DONE PER DART QSI 004.
- 3) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.
- 7) FINISH:

ACID ETCH, ALODINE PER DART QSI 005 4.1, PRIOR TO INSERTING D2976 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.4) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART
QSI 005 4.4 (OPTIONAL) BLACK SANDTEX (REF 4.3.5.7)



01.01.24
IP 01.01.30

| | | | |
|----|----------|-------------------------------|------|
| A2 | 02.10.30 | ADD D3176-1/-3 | # CP |
| A1 | 01.01.24 | CHANGE COLOR TO BLACK SANDTEX | # CP |

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Diagram illustrating the aft fuselage section after repair. The diagram shows a cross-section of the fuselage with the following components and labels:

- BLACK ANTI-SKID**: Points to the anti-skid surface on the floor.
- D2964 CAP**: Points to the cap on the floor.
- 1/16**: Points to the thickness of the floor plate.
- INSTALL D3176-1 (1)**: Points to the installation of the floor plate.
- D3176-3 (1)**: Points to the installation of the floor plate.
- AFTER FINISH**: Points to the finished floor surface.
- Az**: Points to the Azimuth (Az) indicator.

SCALE 1:6

D2976 WEB (REF)

D2973 SPACER

4

ALS7-1032-130 INSERT (34 PLACES)

MS27039-1-08 SCREW (1)
AN960JD10L WASHER (1)
(26 PLACES)

D2964 CAP (REF) SCALE 1:6 D2971 SPACER

PERFORM THE FOLLOWING FOR ~~0.625~~ HOLES ONLY:

5. CHAMFER HOLE 0.030 x 45°
6. INSERT D2971 SPACER
7. WELD INTO PLACE AND GRIND FLUSH
8. PASS ~~0.48~~ DRILL TO REMOVE SPILL OVER
0.150 A

SCALE 1:4

0.40

SEAL WITH
SIKAFLEX-241/-291
ADHESIVE

Ø0.208
- DRILL PRIOR TO D2965 CAP
INSTALLATION (2 PLACES)

MS27039-1-09 NUT (1)
- AN960JD10L WASHER (1)
(2 PLACES)

D2966-1 BENDING/CUTTING DETAIL

R32.0 ± 1.0

6°

6.50

87.19 (REF)




107.06

USE D2962-125 EXTRUSION

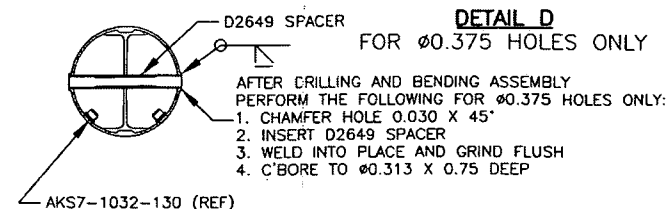
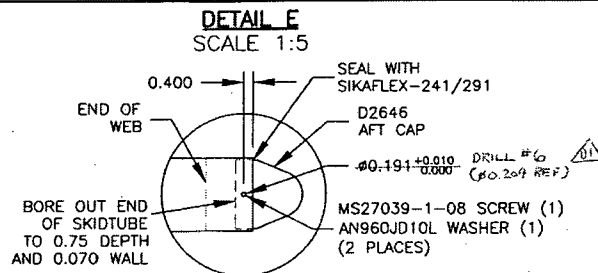
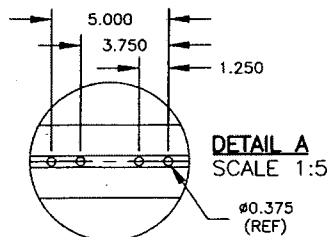
Elevation view of a bridge deck. The deck is shown with a centerline and two side lines. The centerline is labeled with a centerline elevation of $\phi 0.715$ and a width of 5.870 . The side lines are labeled with a side elevation of $\phi 0.625 + 0.010 / 0.000$ (2 PLACES) and a side width of 1.250 . The deck is supported by a pier with a pier elevation of $\phi 0.750 + 0.010 / 0.000$ (14 PLACES). The pier is shown with a pier width of 7.920 and a pier depth of 24.82 . The total width of the bridge deck is 91.62 . The total length of the bridge deck is 67.13 . The bridge deck is shown with a centerline and two side lines. The centerline is labeled with a centerline elevation of $\phi 0.715$ and a width of 5.870 . The side lines are labeled with a side elevation of $\phi 0.625 + 0.010 / 0.000$ (2 PLACES) and a side width of 1.250 . The deck is supported by a pier with a pier elevation of $\phi 0.750 + 0.010 / 0.000$ (14 PLACES). The pier is shown with a pier width of 7.920 and a pier depth of 24.82 . The total width of the bridge deck is 91.62 . The total length of the bridge deck is 67.13 .

D2966-041 ASSEMBLY DETAIL

Diagram illustrating the assembly detail of the D2976 WEB. The main assembly is shown with dimensions: 9.0, 15.3, 51.7, and 16.5. Callouts include: REFER TO DETAIL A, BLACK ANTI-SKID, D2976 WEB, REFER TO DETAIL D, and a section labeled B. Below the main assembly, two sub-assemblies are shown: D2970-1 (with callouts 5 and 5) and D2970-3 (with callouts 5 and 5). A callout 6 points to a detail on the right side of the main assembly.

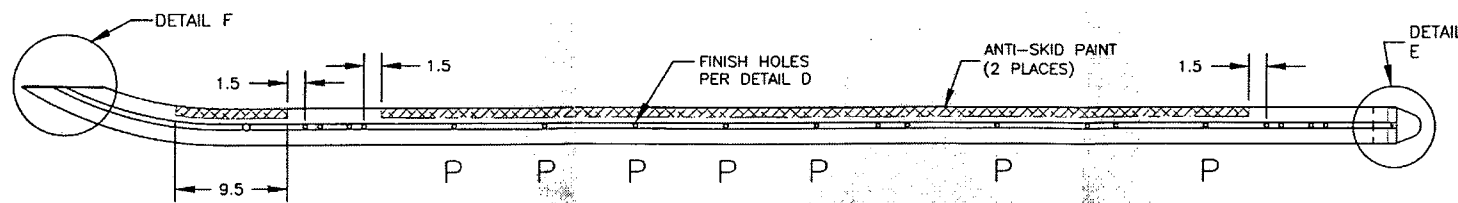
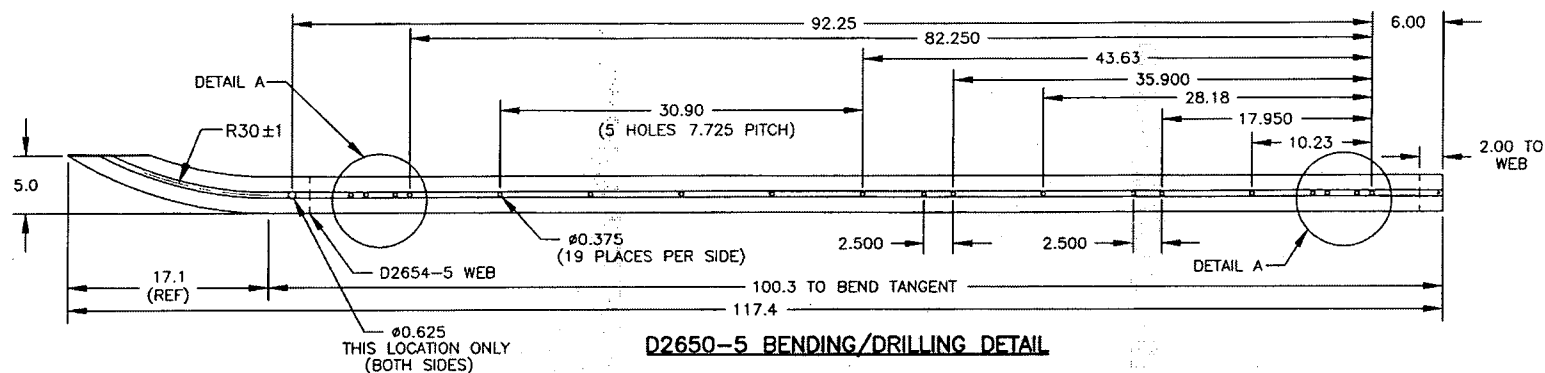
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| | RF | RF | | | |
| |  |  | D2966 | | |
| 00.03.08 | | | BO 105 SKIDTUBE ASSEMBLY | 1:20 | |

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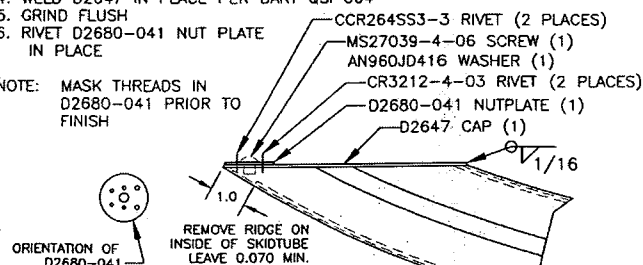
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DETAIL F (NOT TO SCALE)

- CUT TUBE LEVEL
- REMOVE RIDGE ON FWD SIDE
- LOCATE D2647 (TRIM AS NECESSARY)
- WELD D2647 IN PLACE PER DART QSI 004
- GRIND FLUSH
- RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



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| CHECKED | CH | APPROVED | CH | DRAWING NO. D2650 |
| DATE | 04.05.17 | TITLE | SKIDTUBE | REV. D SHEET 4 OF 5 SCALE 1:10 |



